

Work Order ID 165159

Wednesday, August 16, 2017 7:37:37 AM

165159

Page 1

Item ID: D3272-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step
Start Date: 8/16/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 8/21/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: **DAS 21 9-89**

Approvals: Process Plan: **DAS 21 9-89** Date: **AUG 16 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Large Fab	0.00							
100									
Large Fab	Memo	1.20							
Large Fab	***SQUARE ONE END BEFORE CUTTING OTHER END***								
	1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A								
	2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.								
	3-Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

4 x DML 2017-8-16**4/ DAS 38 9-89 AUG 16 2017**

Wednesday, August 16, 2017 7:37:37 AM

Page 2

**DAS
21
9-89**

Picklist Print

Wednesday, August 16, 2017 7:37:44 AM

Page 1

Work Order ID: 165159

165159

Parent Item: D3272-1

D3272-1

Parent Item Name: Step

Start Date: 8/16/2017

Required Date: 8/21/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C		Manufactured	No			100	Each	214.0000	1	4			
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D2622-120C

Step Extrusion

**

IG 2017-08-16

Location

WA003

162484

Loc Qty

214

214

Loc Code

3162484 → 4x



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04-*H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOF COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165159

4-5
1728-16

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 3
DATE	TITLE	SCALE	
07.05.18	STEP ASSEMBLY, HI LONG	1:20	

D.O.I

DETAIL A

116.25
(CUT LENGTH OF D3272-1, REF)

108.93
(DIST FROM FIRST HOLE TO FWD FACE OF SUPPORT)

DETAIL B

1 D3219-1
SUPPORT
(2 PLACES)

D3272-1 STEP

B

D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

RIVET D3065-041
TO D3272-1 USING
MS20600AD4W4 RIVET
(16 PLACES)

1.36
(REF)

0.65
(REF)

GRIND FLUSH
(TYP)

3.375

D3219-1
SUPPORT
(REF)

D3067-1 END PLATE
(2 PLACES)

DETAIL B
(SCALE 1:5)

D3066-1 SPACER
(2 PLACES)

D3065-041
LEG ASSEMBLY

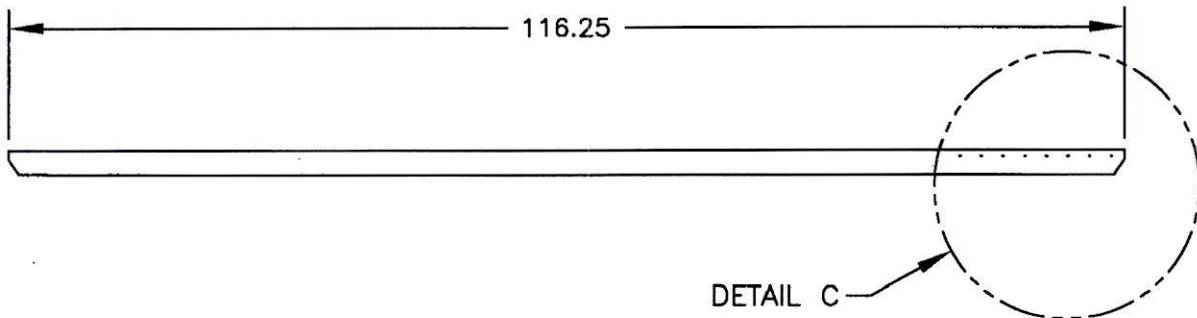
DETAIL A
(SCALE 1:5)

RELEASED

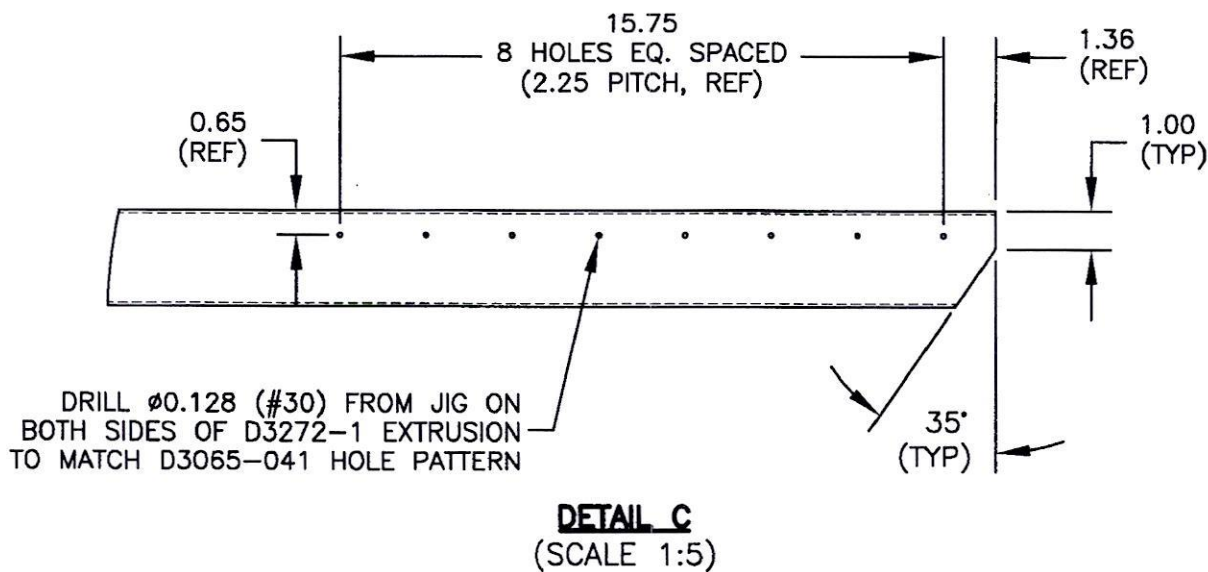
07.06.04

DART

DESIGN	90	DRAWN BY	J.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED	CE	APPROVED	[Signature]	DRAWING NO. D3272	SHEET 3 OF 3
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20



△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



RELEASED

07.06.04 [Signature]